

Date: Friday, 7/4/2008 12:48:40 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE		
Job Number	40280		Part Number	D29322		
Estimate Number	10832		Drawing Number	D2932 REV C		
P.O. Number	:		Project Number	N/A		
This Issue	7/4/2008	S.O. No. :	Drawing Revision	C		
Prsht Rev.	NC		Material	:		
First Issue	/ /		Due Date	7/30/2008	Qty:	10
Previous Run	39180		Um:	Each		
Written By	:		Checked & Approved By	:		6
Comment	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	Saddle Billet, 7075
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: <u>B 34873</u> 08/08/22 10
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr 08/08/24 10
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet J.F. 08/08/25 10
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET J.F. 08/08/25 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 40280

Part Number: D29322

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/08/25

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

n2/m/p

08/08/26

7.0 POWDER COATING POWDER COATING



10X

M108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8-00

01

OVEN TEMPERATURE: 320

8-30

FINISH TIME:

M1 08/08/26

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



MS

Comment: INSPECT POWDER COAT

08-08-26

X10

9.0 PACKAGING 1 PACKAGING RESOURCE #1



10X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 428

8/8/26

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/08/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W08/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40280
Description: 206 Saddle, Outboard, Right side		Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.115	.116	.128	.124		
B	0.100	0.140		.114	.115	.125	.126		
C	0.100	0.140		.105	.105	.124	.124		
D	0.210	0.230		.230	.230	.225	.225		
E	1.245	1.255		1.249	1.256	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.498	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.497	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.316	.316	.316		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.122	.123	.120	.120		
O	0.540	0.560		.549	.551	.550	.550		
P	0.490	0.510		.500	.500	.500	.501		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.470	2.510		2.493	2.493	2.493	2.493		
S	0.240	0.270		.259	.258	.252	.253		
T	0.100	0.180		.136	.136	.139	.139		
U	1.625	1.635		1.628	1.628	1.620	1.620		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321		.317	.317	.317	.317		
X	1.125	1.145		1.137	1.138	1.138	1.139		
Y	1.565	1.585		1.570	1.578	1.570	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>ank/</i>	Audited by:	<i>JL</i>
Date:	<i>08/08/24</i>	Date:	<i>08/08/29</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>JL</i>

DART AEROSPACE LTD		Work Order: 40280
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2	
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125	.125	.128	.128		
B	0.100	0.140		.124	.125	.128	.128		
C	0.100	0.140		.124	.120	.125	.125		
D	0.210	0.230		.225	.226	.223	.225		
E	1.245	1.255		1.256	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.251	1.251	1.251		
G	2.495	2.505		2.495	2.501	2.501	2.501		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.579	1.579	1.579		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	Ø.258	Ø.258	Ø.258		
L	0.312	0.317		.317	Ø.313	Ø.313	Ø.313		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.139	.122	.119	.121		
O	0.540	0.560		.548	.595	.547	.547		
P	0.490	0.510		.501	.501	.503	.502		
Q	3.715	3.725		3.720	3.718	3.718	3.718		
R	2.470	2.510		2.463	2.493	2.493	2.493		
S	0.240	0.270		.253	.252	.258	.258		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.620	1.629	1.629	1.629		
V	1.362	1.372		1.368	1.368	1.368	1.368		
W	0.316	0.321		.317	Ø.316	Ø.316	Ø.316		
X	1.125	1.145		1.138	.139	.138	.138		
Y	1.565	1.585		1.572	.173	1.567	1.573		
Z	0.178	0.198		.186	R.188	R.188	R.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JK	J.F.	Audited by:	JK
Date:	08/08/24		Date:	08/08/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	RF

•DART AEROSPACE LTD				Work Order:	40280
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-2
Inspection Dwg: D2933	Rev: C	DSK:	Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140	,	1.28"	1.28"			
B	0.100	0.140	,	1.28"	1.28"			
C	0.100	0.140	,	1.25"	1.25"			
D	0.210	0.230	,	2.23"	2.23"			
E	1.245	1.255	,	1.250"	1.250"			
F	1.245	1.255	,	1.251"	1.251"			
G	2.495	2.505	,	2.501"	2.501"			
H	0.510	0.515	,	510"	510"			
I	1.572	1.582	,	1.579"	1.579"			
J	2.495	2.505	,	2.500"	2.500"			
K	0.257	0.262	,	0.258"	0.258"			
L	0.312	0.317	,	0.313"	0.313"			
M	0.235	0.240	,	0.237"	0.237"			
N	0.100	0.140	,	0.118"	0.119"			
O	0.540	0.560	,	0.548"	0.548"			
P	0.490	0.510	,	0.503"	0.504"			
Q	3.715	3.725	,	3.718"	3.718"			
R	2.470	2.510	,	2.493"	2.493"			
S	0.240	0.270	,	0.258"	0.257"			
T	0.100	0.180	,	0.140"	0.140"			
U	1.625	1.635	,	1.629"	1.629"			
V	1.362	1.372	,	1.368"	1.368"			
W	0.316	0.321	,	0.316"	0.316"			
X	1.125	1.145	,	1.130"	1.131"			
Y	1.565	1.585	,	1.569"	1.571"			
Z	0.178	0.198	,	0.182" 0.183"	0.188"			
AA								
AB								
AC								
AD								
AE								

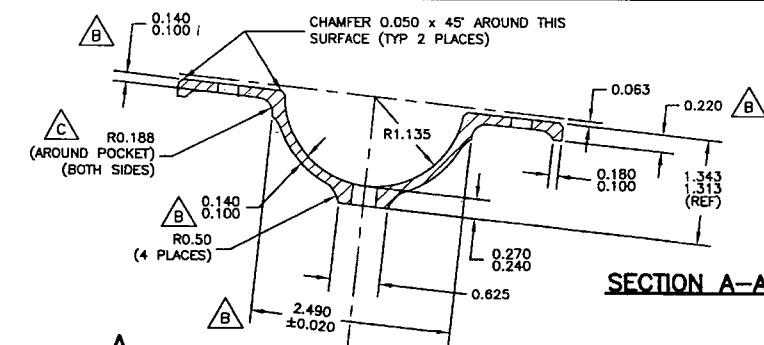
Accept/Reject

Measured by: J.F. 08/08/24 Date: 08/08/24

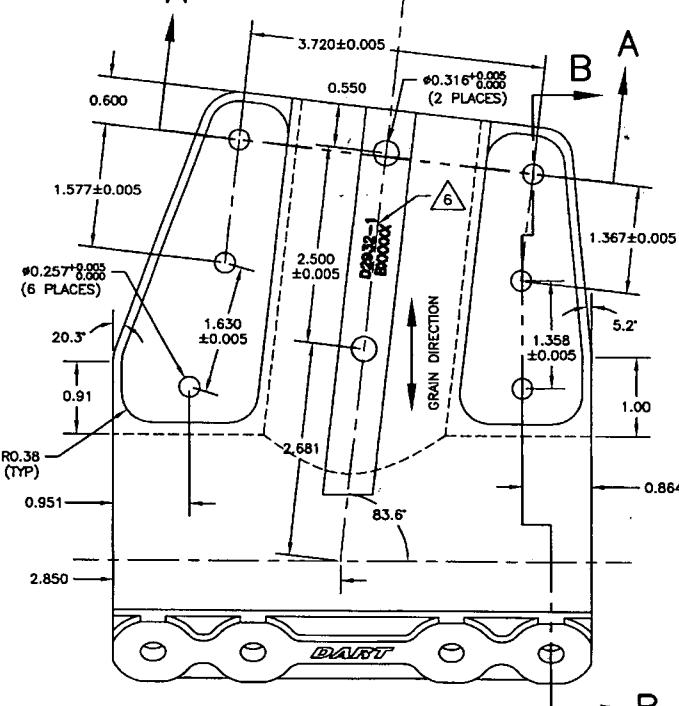
Audited by: JL Date: 08/08/29

Prototype Approval: N/A Date: N/A

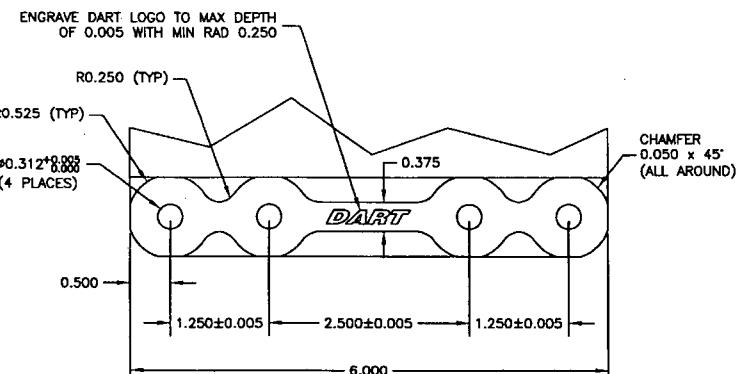
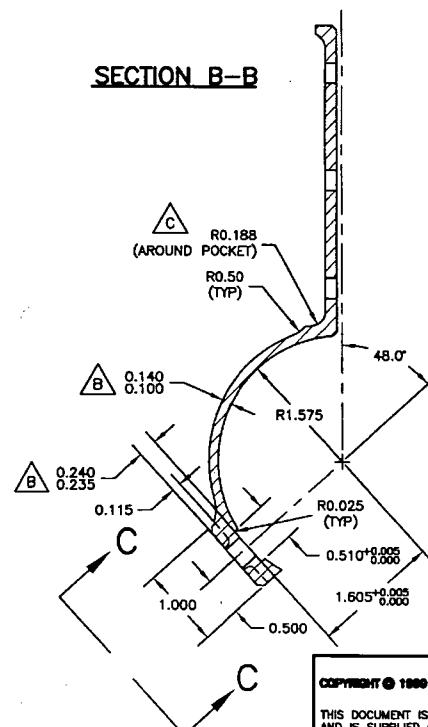
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QO-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE SCALE 2:3
		DRAWING NO. D2932 SHEET 1 OF 1
		REV. C

RELEASED
07-02-12

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